

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 06/04/04
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/27/2006 4:22:09 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 25997

Part Number: D2572

Job Number:



Seq. #: Machine Or Operation:

Description :

4.0 QC2

INSPECT PARTS AS THEY COME OFF MACHINE



109

6/0

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

EP/J.G. 06/03/27 8

5.0 QC8

SECOND CHECK



Comment: SECOND CHECK

FL 06/03/29 8

6.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

AM 06-03-29 6

7.0 POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

DC 06/04/02 8

8.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FL 8/4/3 8

9.0 PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 419

FL 8/4/3 8

10.0 DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

FL 06/04/01 8

Job Completion



FL 06/04/04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD				Work Order:	25997
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	0.438	0.438	0.438	0.438		
B	1.745	1.755		1.747	1.746	1.745	1.746		
C	3.495	3.505		3.497	3.496	3.497	3.495		
D	1.745	1.755		1.747	1.746	1.745	1.746		
E	7.990	8.010		8.004	8.004	8.003	8.003		
F	0.490	0.510		0.498	0.497	0.497	0.500		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.501	0.493	0.497	0.495		
J	1.174	1.184		1.177	1.177	1.177	1.177		
K	0.558	0.578		0.569	0.567	0.565	0.566		
L	1.174	1.184		1.177	1.177	1.177	1.177		
M	1.490	1.500		1.495	1.493	1.494	1.493		
N	2.495	2.505		2.497	2.497	2.495	2.497		
O	3.869	3.879		3.874	3.872	3.873	3.873		
P	0.115	0.135		0.124	0.127	0.128	0.127		
Q	0.115	0.135		0.125	0.130	0.130	0.130		
R	0.240	0.260		0.245	0.252	0.253	0.253		
S	0.115	0.135		0.122	0.118	0.121	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.241	0.232	0.232	0.232		
W	0.115	0.135		0.125	0.123	0.123	0.124		
X	0.307	0.312		0.310	0.310	0.318	0.316		
Y	0.760	0.765		0.760	0.766	0.760	0.760		
Z	0.352	0.372		0.360	0.362	0.362	0.360		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.620	0.622	0.625	0.626		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.249	0.245	0.246	0.246		
AE	1.375	1.395		1.388	1.391	1.390	1.388		
AF	0.115	0.135		0.120	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.244	0.244	0.247	0.247		
AI	2.000	2.020		N/A	N/A	N/A	N/A		
AJ	0.023	0.043		0.033	0.030	0.030	0.030		
Accept/Reject									

Measured by:	3-G /	Audited by:	OPC
Date:	06/03/25	Date:	06/03/29

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD				Work Order:	25991
Description: Saddle, Fwd Inboard				Part Number:	D2572
Inspection Dwg: D2572 Rev. E				Page 1 of 1	

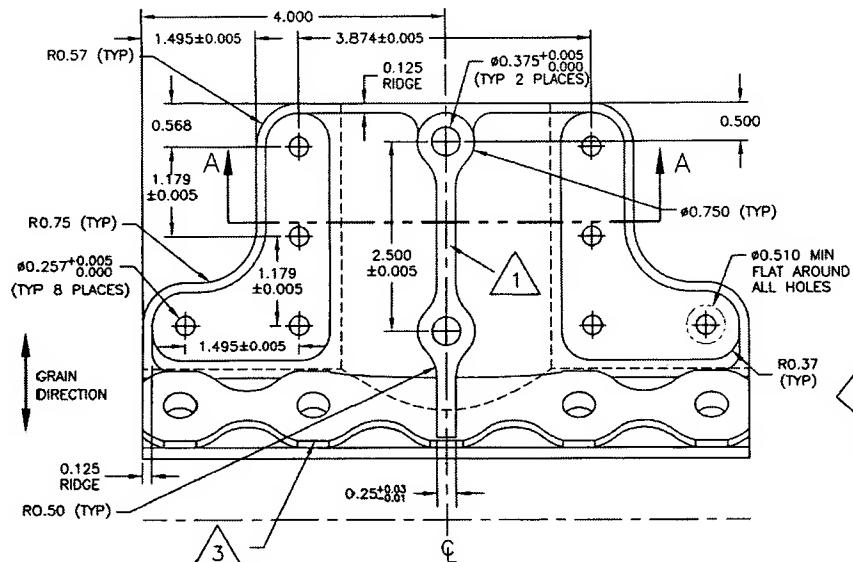
Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
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B	1.745	1.755		1.746	1.746	1.745	1.745		
C	3.495	3.505		3.496	3.495	3.496	3.496		
D	1.745	1.755		1.746	1.746	1.745	1.745		
E	7.990	8.010		8.004	8.003	8.003	8.004		
F	0.490	0.510		0.496	0.497	0.496	0.496		
G	0.257	0.262	DT8683	0.257	0.257	0.257	0.257		
H	0.375	0.380	DT8684	0.375	0.375	0.375	0.375		
I	0.490	0.510		0.494	0.496	0.496	0.495		
J	1.174	1.184		1.178	1.178	1.177	1.177		
K	0.558	0.578		0.566	0.561	0.562	0.565		
L	1.174	1.184		1.178	1.178	1.177	1.177		
M	1.490	1.500		1.495	1.494	1.493	1.494		
N	2.495	2.505		2.497	2.496	2.496	2.497		
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Q	0.115	0.135		0.130	0.130	0.130	0.130		
R	0.240	0.260		0.252	0.252	0.253	0.252		
S	0.115	0.135		0.120	0.121	0.119	0.121		
T	0.178	0.198		0.188	0.188	0.188	0.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		0.232	0.236	0.236	0.239		
W	0.115	0.135		0.123	0.123	0.124	0.124		
X	0.307	0.312		0.310	0.310	0.310	0.310		
Y	0.760	0.765		0.760	0.760	0.760	0.760		
Z	0.352	0.372		0.370	0.369	0.369	0.362		
AA	0.470	0.530		0.500	0.500	0.500	0.500		
AB	0.615	0.635		0.624	0.625	0.622	0.623		
AC	0.053	0.073		0.063	0.063	0.063	0.063		
AD	0.240	0.260		0.246	0.246	0.249	0.248		
AE	1.375	1.395		1.386	1.387	1.387	1.386		
AF	0.115	0.135		0.130	0.130	0.130	0.130		
AG	0.240	0.280		0.260	0.260	0.260	0.260		
AH	0.240	0.260		0.245	0.245	0.250	0.251		
AI	2.000	2.020		W/4	W/4	W/4	W/4		
AJ	0.023	0.043		0.030	0.030	0.030	0.030		

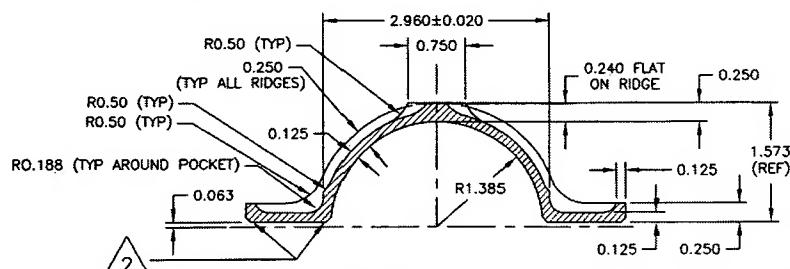
Accept/Reject

Measured by:	EP	Audited by:	SM
Date:	06/03/28	Date:	06/03/29

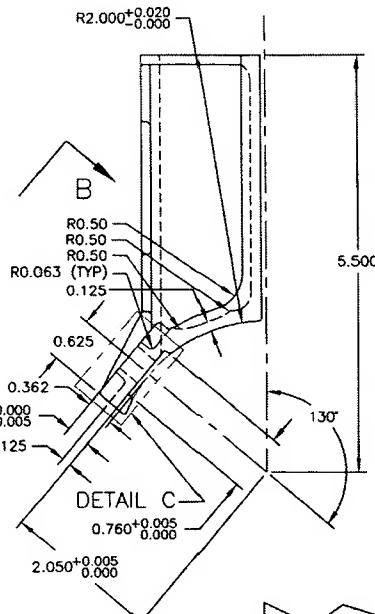
Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



SECTION A-A



DETAIL C
SCALE 2:1

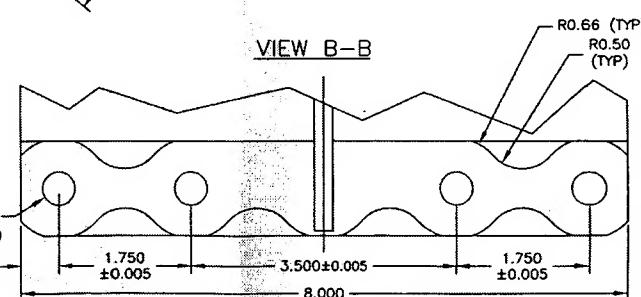


NOTES

MATERIAL: 7075-T7351 (QQ-A-250/12)
(REF DART SPEC. D6102-003)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER
DART QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 3 CHAMFER 0.063 x 45° ALL AROUND
- 4 CHAMFER 0.033 x 45° (SEE DETAIL C) E

VIEW R-E



E	05.07.13	ADD CHAMFER ON RIDGE NOTE 4
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE

		50.05.10	NEW ISSUE		
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		CHECKED	APPROVED	D2572	SHEET 1 OF 1
		DATE	TITLE		SCALE
		05.07.13	INNER FWD SADDLE		2:1